

Work Order ID 72066

Friday, July 22, 2011 10:03:02 AM



Ship Aug 1000
MAT BLACK

Page 1

Item ID: D2571

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd Out 205

Stop



Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-07-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 72066 F.K. Double check by: *AK* ☐ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA051 and inspect

AK 11/08/05

2 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

AK 11/08/05

2 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

AK 11/08/05

2 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72066

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Page 2

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 11/08/08

2

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

2x 0 M-11/08/08

145



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

11/15/28

START TIME: 2:30p ~ OVEN TEMPERATURE:
3:00p ~ FINISH TIME: 320°

2 0 M-11/08/08

W/O:		WORK ORDER CHANGES					
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Work Order ID 72066

Friday, July 22, 2011 10:03:02 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

2X ~~QC~~ M-11/08/08

170



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

P-4443 (2)

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 11/08/10

R11-08-9
G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 9:03:21 AM

Page 1

Work Order ID: 72066

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205



Start Date: 7/19/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured No

100

Each

23.0000

1

2



Saddle Billet



OK F.K. - 11/08/04

Location

Loc Qty

Loc Code

MAT045

23

65383

1

65954

4

70680

18

B71722

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order:	72066
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.440				
B	1.745	1.755		1.748	1.748				
C	3.495	3.505		3.498	3.500				
D	1.745	1.755		1.748	1.748				
E	7.990	8.010		8.004	8.003				
F	0.490	0.510		.504	.501				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.178	1.177				
K	0.558	0.578		.567	.566				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.493	1.493				
N	2.495	2.505		2.499	2.498				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		.123	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.248	.250				
S	0.115	0.135		.123	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.960				
V	0.230	0.250		.239	.237				
W	0.115	0.135		.120	.121				
X	0.308	0.313		.312	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.364	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.243	.247				
AE	1.375	1.395		1.384	1.388				
AF	0.115	0.135		.133	.130				
AG	0.240	0.280		.255	.255				
AH	0.240	0.260		.248	.247				
AI	2.000	2.020		2.000	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	SMZ
Date:	11/08/05

Audited by:	B.A
Date:	11/08/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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NO. 1204

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 

DESIGN	DRAWN BY		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE	SCALE 2:3

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DETAIL C
SCALE 4:3

Dart Aerospace Ltd

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